

Date: Wednesday, 3/14/2007 3:32:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 31231		Part Number	: D2591	
Estimate Number	: 10008		Drawing Number	: D2591 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/14/2007 S.O. No. : N/A		Drawing Revision	: D	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 3/14/2007 Type : MACHINED PARTS		Due Date	: 3/27/2007 Qty: 60 Um: Each	
Previous Run	: 30056				
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:I Removed from 9 Digit 05-10-25 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
		Comment: Qty.: 0.2340 f(s)/Unit Total : 14.0400 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M103069	J.L 07/03/18
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.700" long	J.L 07/03/18
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required	J.F / J.L 07/03/19 (60)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F / J.L 07/03/19 (60)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.L 07.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31231
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article



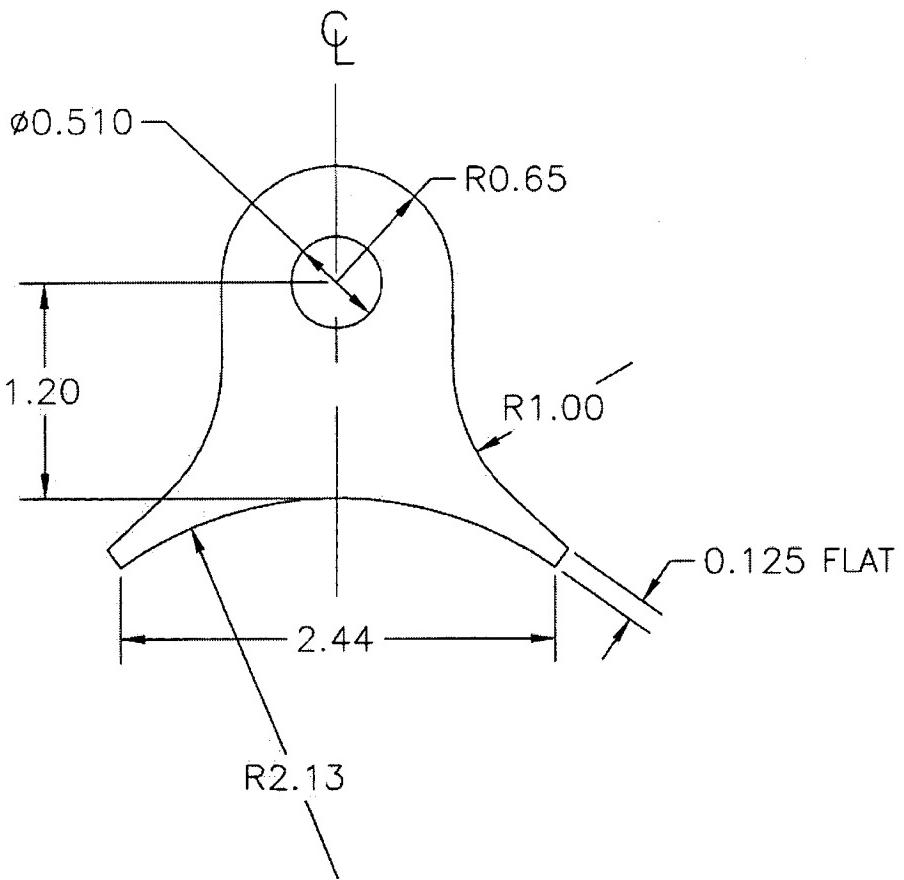
Prototype

Measured by:	J.L	Audited by:	MJ	Prototype Approval:	N/A
Date:	07/03/18	Date:	07/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DS1 9161-011	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN <i>INCH</i>	DRAWN BY <i>INCH</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
 98.01.21 DS


BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
 MATERIAL: ASTM A36 STEEL 0.50 THICK
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 PART IS SYMMETRIC ABOUT CENTER-LINE
 ALL DIMENSIONS ARE IN INCHES

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 31231